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Titel:

Zusammenfassung

PROBLEM TO BE SOLVED: To restrain the occurrence of rubber fragment and realize an excellent coring-resistance, by laminating the upper face of the top of a rubber stopper, at least the portion which is pierced with a syringe needle, with a porous fluoroplastic film.

SOLUTION: An unvulcanized, vulcanizable rubber composition 1 in a sheet form is made by mixing and kneading raw rubber and various compounding agents, such as vulcanizable filler and coloring agent, which are suitable for the raw material. Then, the unvulcanized, vulcanizable rubber composition 1 in the sheet form, obtained in such a way, and a porous fluoroplastic film 2 are superimposed one on the other, and they are placed onto a lower mold 3 of a specific shape so that the rubber side faces it. Subsequently, an upper mold is disposed onto the film 2 and compression molding and vulcanization are carried out at the same time. After the specific length of time, the pressure is removed and the formation is taken out of the molds. Thus, a rubber stopper in which a top face and the upper face and side-face of a flange 6 are laminated with the porous fluoroplastic film 2 is obtained. As the porous fluoroplastic film 2, polytetrafluoroethylene or the like is used.

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